

Work Order ID 146297

Monday, May 16, 2016 1:08:08 PM

146297

Page 1

Item ID: 647.0110

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Roof Doubler

Start Date: 5/25/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: dm Date: 16/05/16

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.0100	A1

110 0.00

110

Waterjet

Memo

0.06

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A1

Prog Rev: A1

2-Deburr if necessary

120 QC2- Inspect parts off machine FAI/FAIB 0.00

120

QC

Memo

0.01

Quality Control

PR 06/13/2016

3

3 PR 06/13/2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 146297***146297***

Page 2

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Item Name: Roof Doubler

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Required Date: 6/15/2016 Req'd Qty: 1.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.02

Quality Control

JUN 14 2016

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Memo

80.00

Outsource process - Anodize

Issue P/O to ATG : 32760

1- Black Anodize as per Dwg 647.0100

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Conformity is required

JUN 20 2016

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.02

Packaging

CL 16/06/30 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Work Order ID 146297

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Page 3

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
160									
QC	Memo	0.02							111 04 2016
Quality Control									
190	Identify as per dwg & Stock Location: <u>Stock</u>	0.00							
190									
Packaging	Memo	0.01							JUL 07 2016 DAS 6 9-89
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.10							16/7/12 JF
Quality Control									DAS 21 9-89 JUL 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		☐ OTHER : _____							

Picklist Print

Monday, May 16, 2016 1:08:13 PM

Page 1

Work Order ID: 146297

146297

Parent Item: 647.0110

647 0110

Parent Item Name: Roof Doubler

Start Date: 5/25/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	162.2080	2.466	2.595789			

M2024T3S 063

2024-T3 .063 sheet

**

PR 06/13/2016

Location	Loc Qty	Loc Code
MAT	17.49	
m133548	17.49	
MAT009	25.98	
m134157	25.98	7.9
MAT022	22.738	
m130000	7.088	
m130525	15.65	
TPI	96	
m134640	96	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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								Lead hand / Supervisor Approval Verification	
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OTHER : ☐									

DQA: _____ Date: _____

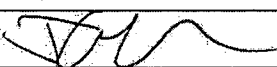
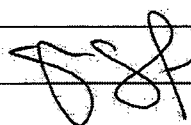


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QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03985			SHEET 1 OF 2	
	DWG NO. 647.0100	REV: A	PREPARED BY J. BECKER	DATE: 7/15/13	EFFECT ON DWG ☐ INC. ☒ UNINC.
	DWG TITLE: SHEET METAL				
	APPROVED BY: ENGR. 	MFG. 	QC. 	EFF. NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED NOTE 2. ADDED 647.0117				

IS

NOTES:

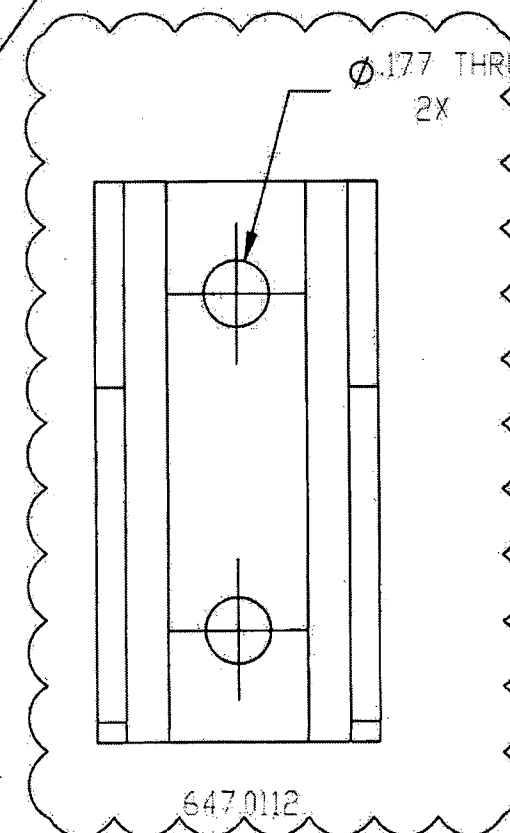
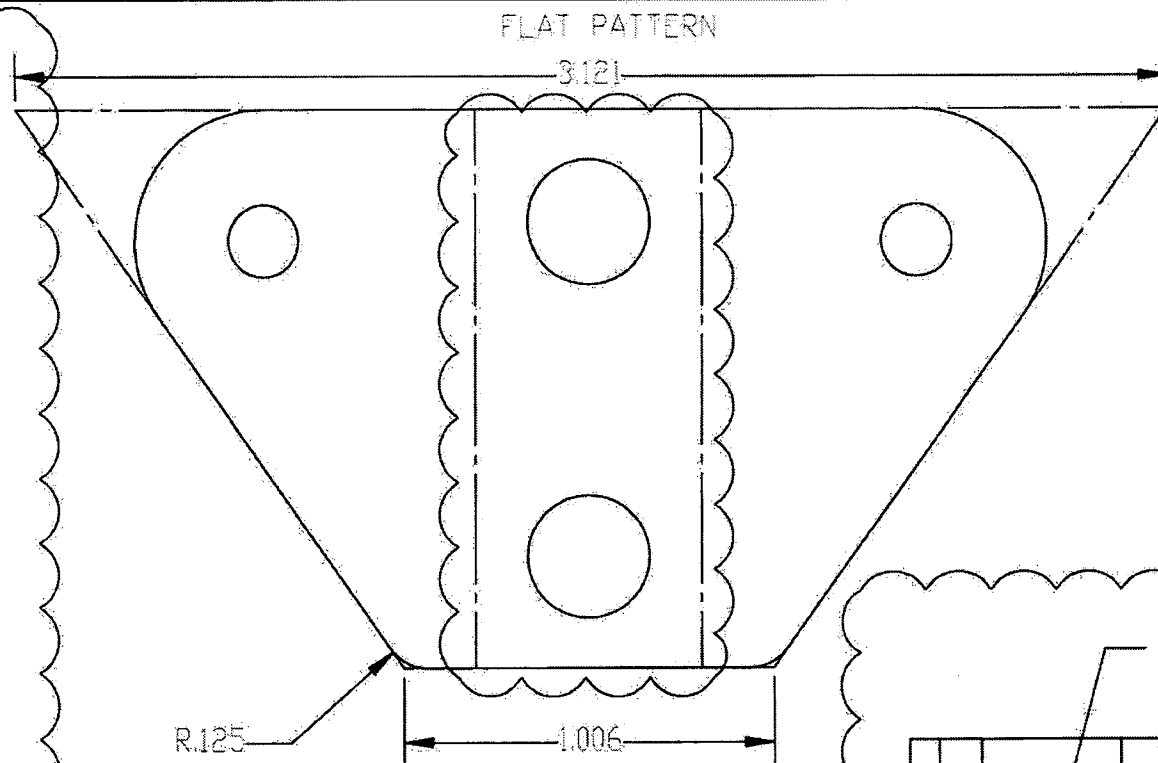
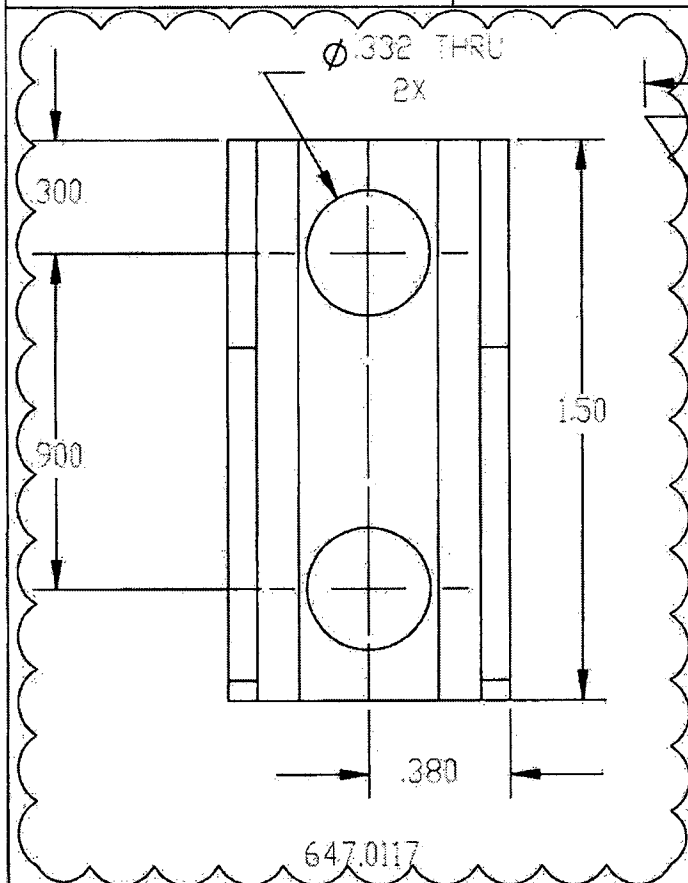
- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- 2 FINISH: IAW MPP-172 ANODIZE IAW SECTION 2.1, PRETREATMENT IAW SECTION 3.1 AND PRIMER IAW SECTION 4.1.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.
- 7 OTHER DIMENSIONS SAME AS 647.0112.

SHEET 1, ZONE D1 IS:

C	647.0117		STRUT BRACKET	△	△
F/N TC	PART NUMBER		DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:			CHANGE CATEGORY	DER REVIEW REQUIRED	
☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM			☐ MAJOR ☒ MINOR	☐ YES ☒ NO	

w/o 146297

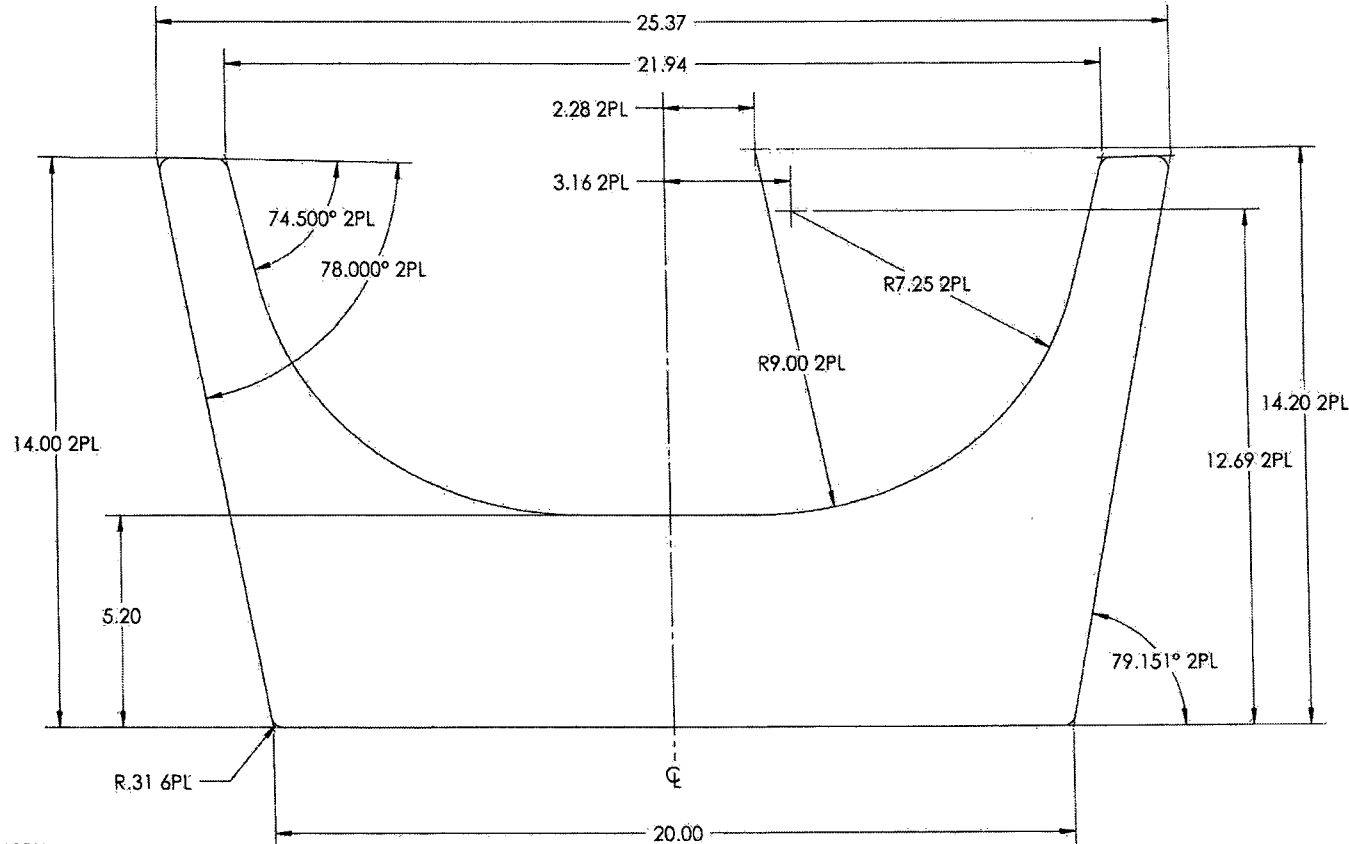
dm 16/05/16



SHEET 3, ZONE B2-4 IS:

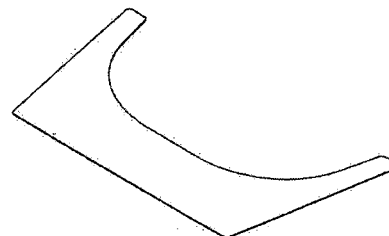
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION #87		N/C
2	INITIAL RELEASE	03/28/09	P. BRAVO
3	INCORPORATED ECN 02777, 02944, 03009	04/16/11	P. BRAVO



NOTES:

1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
5. MATERIAL: 304 SS IAW AMS 5643.
6. FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.



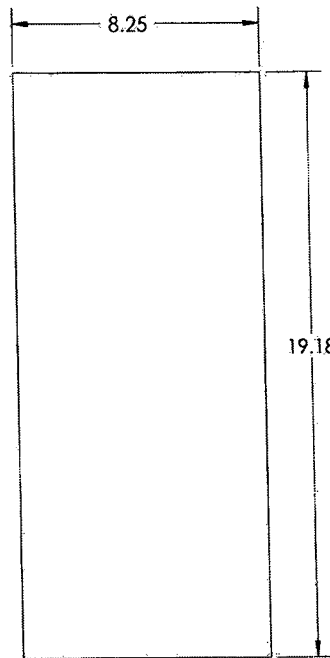
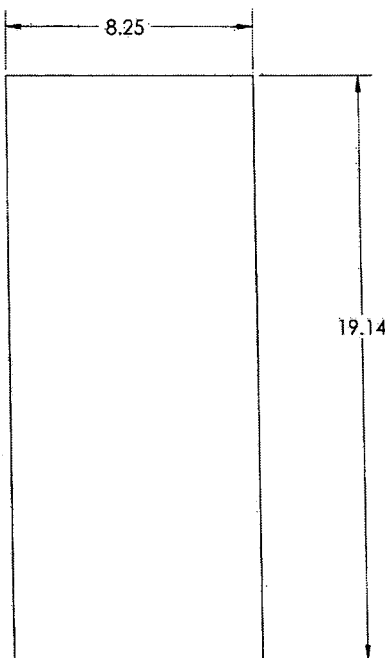
647.0110

UNINCORPORATED ECN(S)

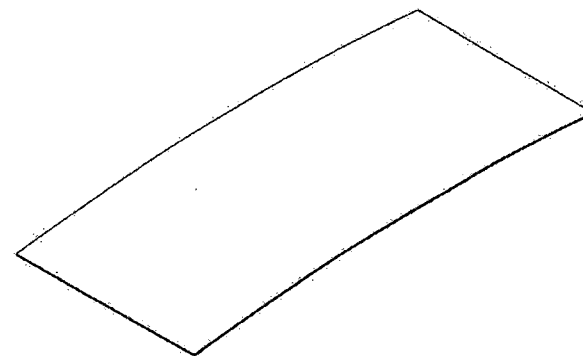
03985

QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC.
		647.0116	DOUBLER	△	△
		647.0115	CLIP	△	△
		647.0114	CLIP	△	△
		647.0113	STRUT DOUBLER	△	△
		647.0112	STRUT BRACKET	△	△
		647.0111	PANEL	△	△
		647.0110	ROOF DOUBLER	△	△
PARTS LIST					
NEXT ASSY (S)			APICAL INDUSTRIES		
646.9500			2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
			SHEETMETAL		
			SIZE: 07X26	DWG: 647.0100	REV: A
			SCALE: NONE	SHEET 1 OF 6	

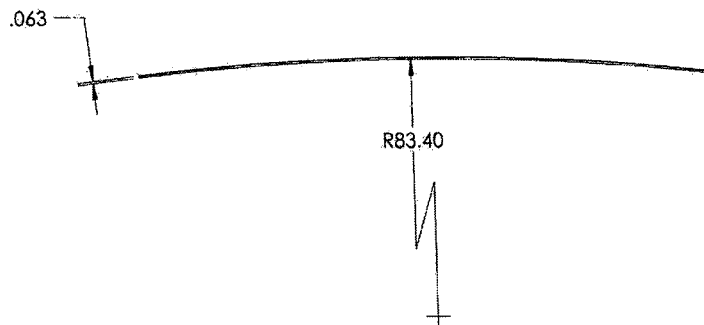
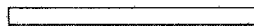
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FLAT PATTERN



647.0111



ORIGINAL DATE 10-01-81		ISSUED BY P. BRAVO	
DRAWN BY R. ROSAND		CHECKED P. BRAVO	
DRAWING APPROVAL P. BRAVO		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .001 ANGLES ± .5°		REV. NO. 07/02/86	REV. A
SCALE: NONE		SHEET 2 OF 6	

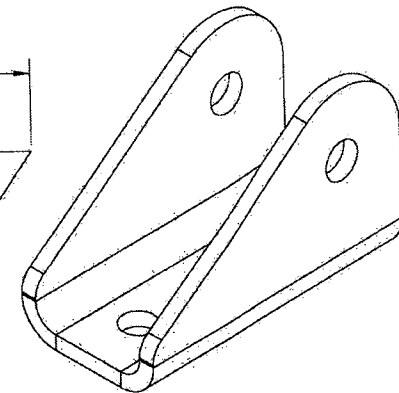
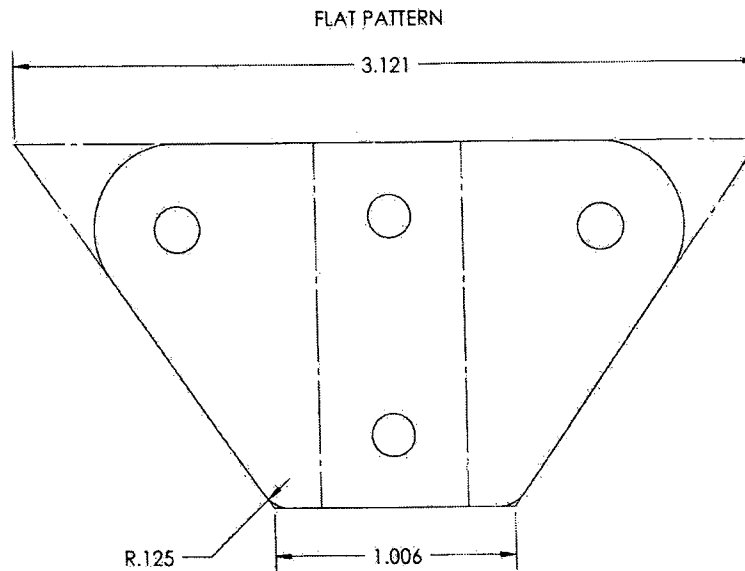
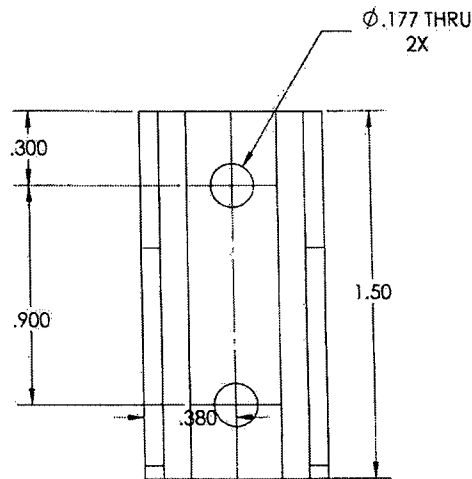
APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760) 724-5300

SHEETMETAL

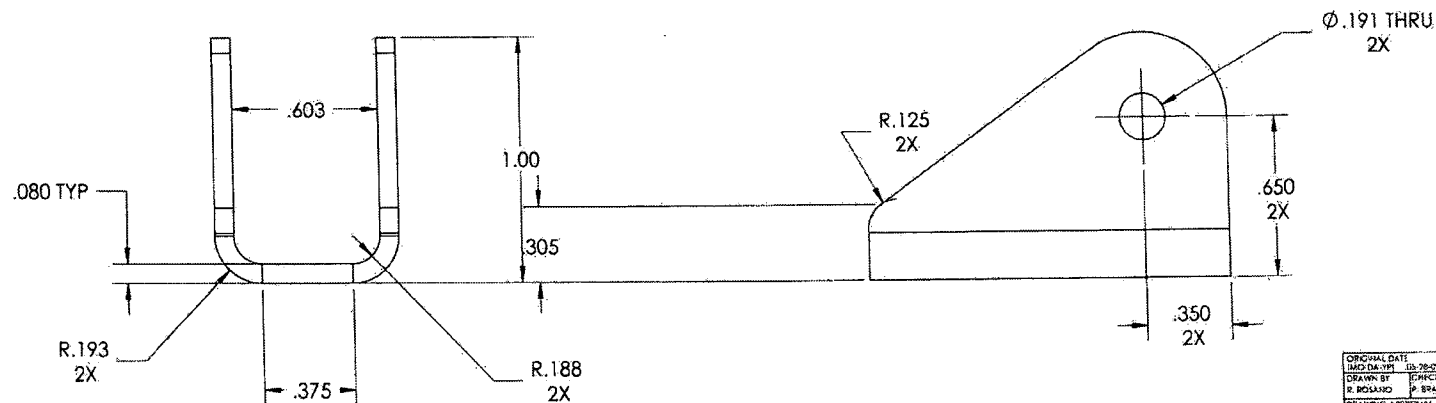
647.0100

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0112



ORIGINAL DATE: 03-28-07
 DRAWN BY: J. BRAYO
 R. ROSARIO
 DRAWING APPROVAL: J. BRAYO
 CONTRACT NO.

APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760)724-5300

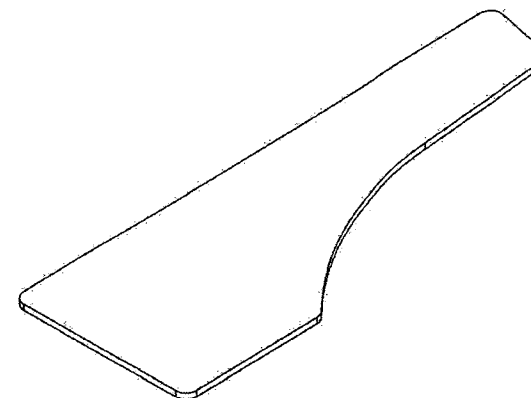
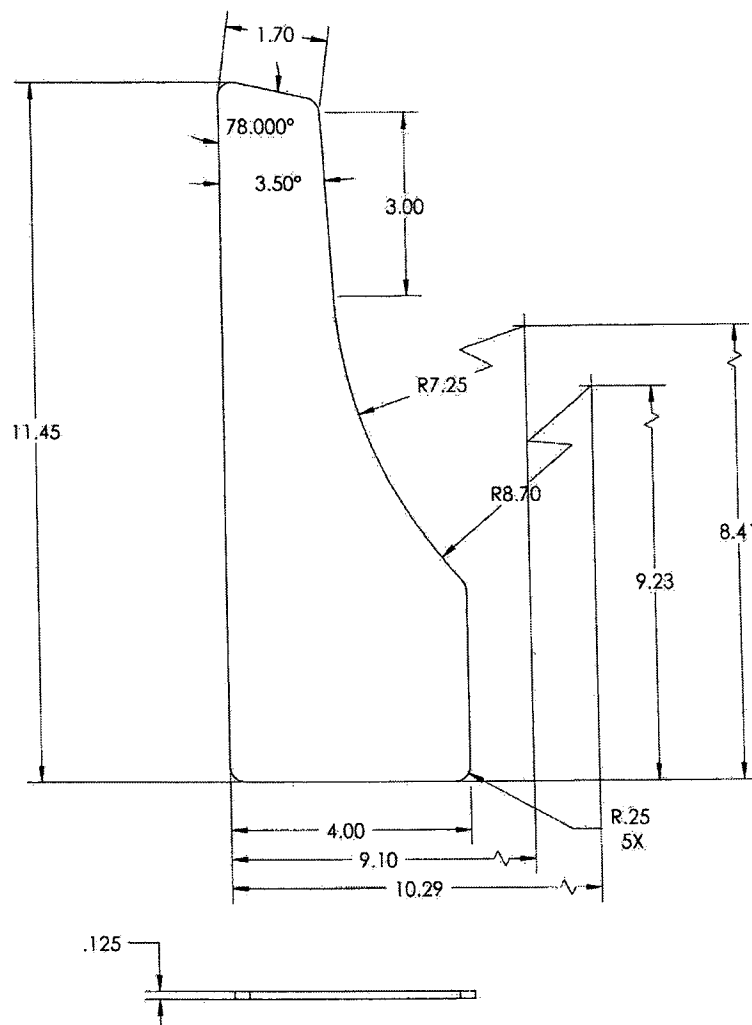
SHEETMETAL

UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES
 TOLERANCES ARE:
 3 PLACES DECIMALS ±.01
 ANGLES ±.5°

SHEET CODE: 8 DWG. NO: 647.0100 REV: A
 SCALE: NONE SHEET 3 OF 6

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REV.	DESCRIPTION	DATE	APPROVED

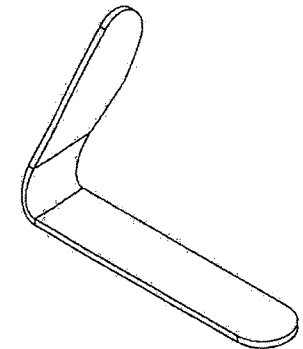
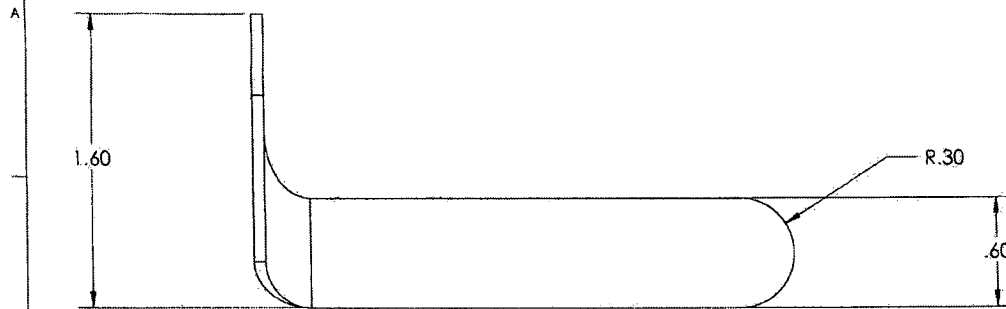


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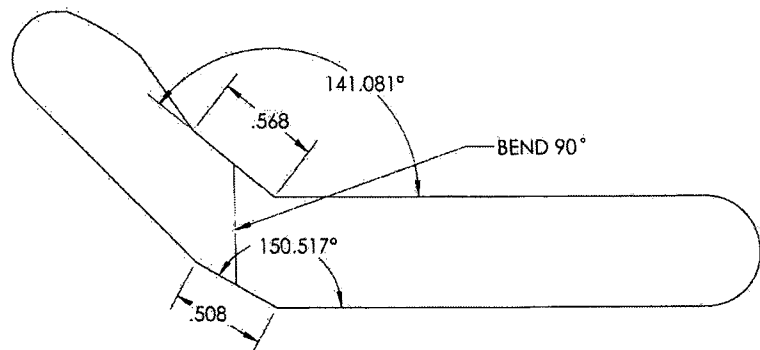
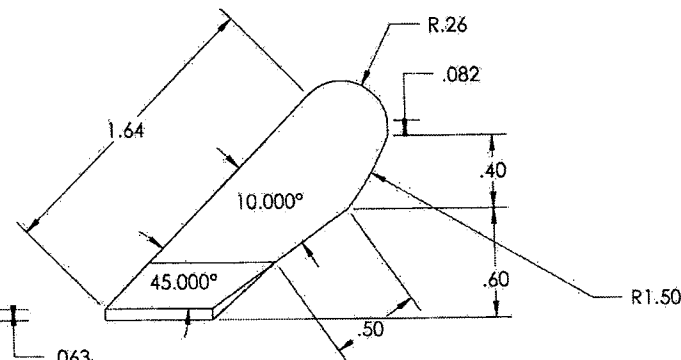
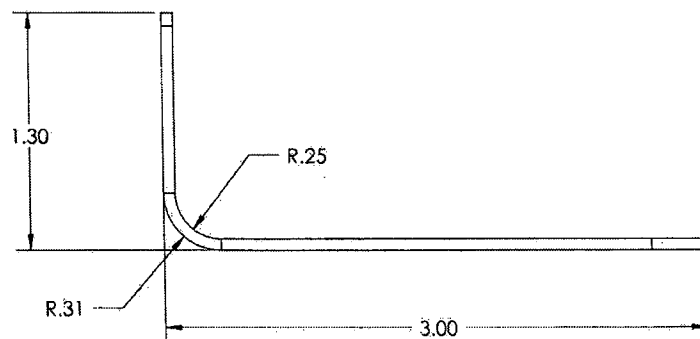
ORIGINAL DATE JANUARY 05, 2009	APICAL INDUSTRIES		
DRAWN BY P. ROSANO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300		
CHECKER P. BRAYO	SHEETMETAL		
DRAWING APPROVAL P. BRAYO	SHEET CODE 8 07M16	DWG. NO. 647.010	REV. A
CONTRACT NO.	SCALE NONE		SHEET 4 OF 6

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0114 SHOWN
647.0115 OPPOSITE

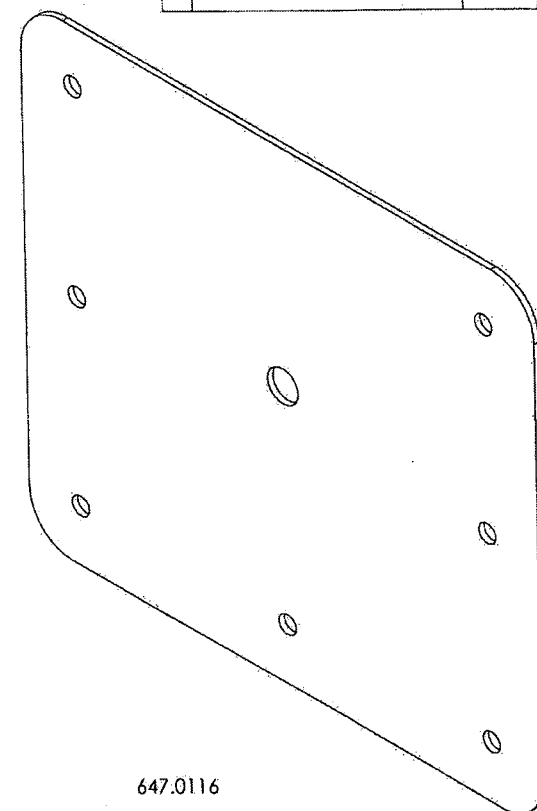
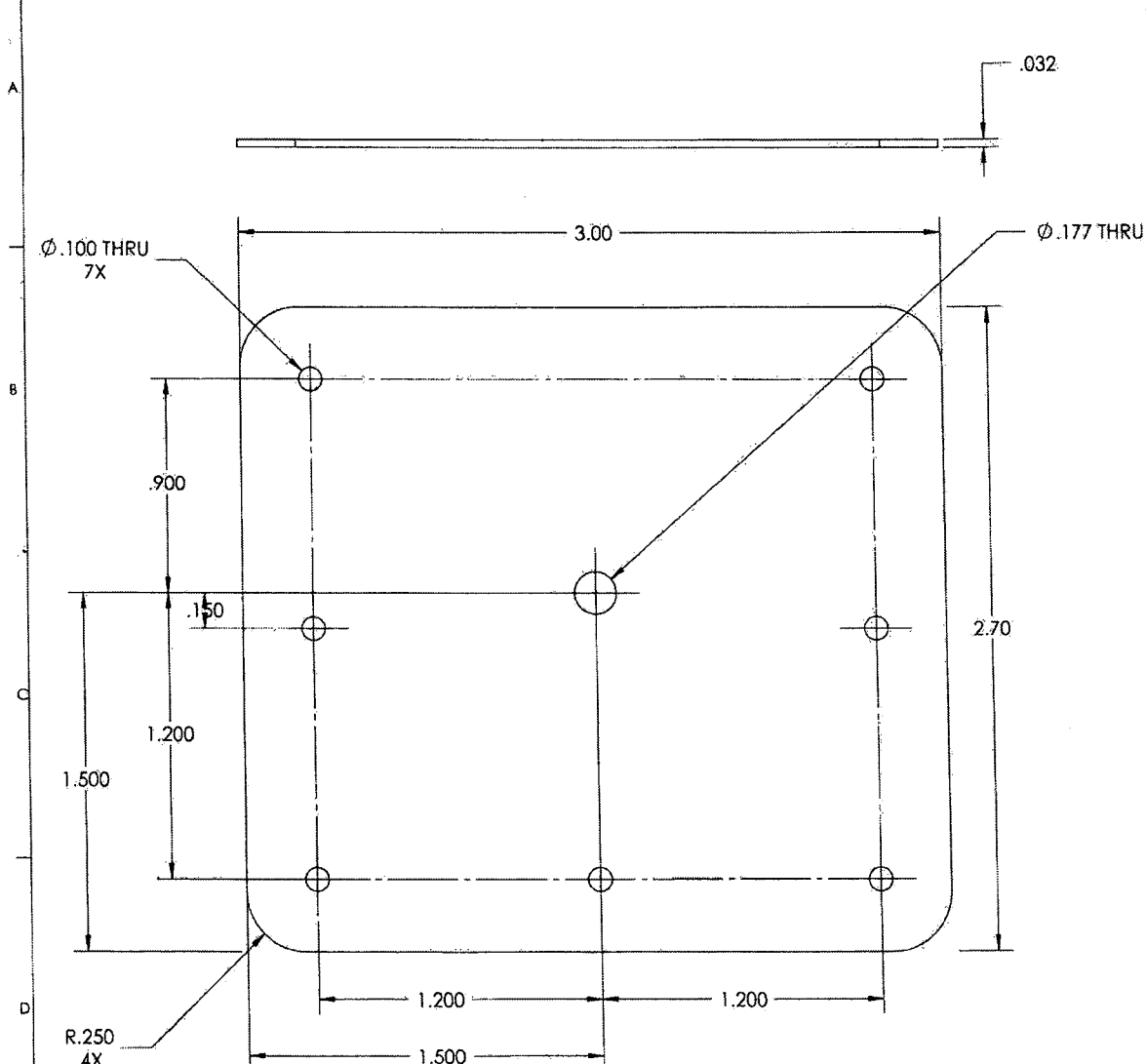


FLAT PATTERN

ORIGINAL DATE 05-28-09		APICAL INDUSTRIES	
DRAWN BY R. FOSANO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY D. BRAVO		SHEETMETAL	
DRAWING APPROVAL P. BRAVO		SIZE B	DWG. NO. 647.0100
CONTRACT NO.		SCALE NONE	SHEET 5 OF 6

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0116

ORIGINAL DATE 03-28-89		APICAL INDUSTRIES	
DRAWN BY P. POSANO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
CHECKED BY P. BRAYO		SHEETMETAL	
DRAWING APPROVAL P. BRAYO		SHEET 6 OF 6	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SHEET 6 OF 6	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO32760

Purchase Order Date 6/20/2016

PO Print Date 6/27/2016

Page Number 1 of 7

Order From : VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

Contact Name

Vendor Phone 613-446-4544

Vendor Fax 613-446-4556

Ship To Contact

Ship To Phone

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship Method VENDOR'S TRUCK

Ship Acct

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
5	141006	646.3012 LOWER GUIDE REV. N/C	6/30/2016 Yes	16.00	\$318.40

6/30/2016

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

ALODINE NEED TO REMOVE

Line Total:

\$318.40

6 146297 647.0110 ROOF DOUBLER
REV. A

6/30/2016
Yes

3.00

\$129.00

6/30/2016

CL 16106130

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total:

\$129.00

6/27/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 911901

Date: 29-Jun-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.			
13 ea	Part: 147818 D5312-1 Tie Down Job: 19717	Rev: PO: 32760	Line:
10 ea	Part: 146966 D4726-1 Handle Job: 19709	Rev: PO: 32760	Line: 11
6 ea	Part: 146730 647.1513 Upper deflector Job: 19712	Rev: C PO: 32760	Line: 16
3 ea	Part: 146297 647.0110 Roof doubler Job: 19704	Rev: A PO: 32760	Line: 6
6 ea	Part: 147224 647.2114 Job: 19705	Rev: C PO: 32760	Line: 7
DATE: 29/6/16			
CERTIFIED SIGNATURE: [Signature]			
RECEIVER SIGNATURE: [Signature]			
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
CERTIFICATE OF CONFORMANCE			
A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO			